

Work Order ID 141770

February 11, 2016 10:27:08 AM

141770

Item ID: D3782-045

Accept

N900040100

Setup Start ***NS1**

Revision ID:

Item Name: Back Leg Assembly

Stop ***NS2**

Start Date: 2/11/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/16/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: SLA

Date: 2 1 6 0 2 1 Tooling:

Date:

Run Start ***NR1**

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp Start
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Draw Nbr	Revision Nbr
----------	--------------

D3782	Rev B
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100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

100

Packaging Memo

0.00

FEB 11 2016

Packaging

DAS
6
9-89

110	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

110

Small Fab Memo

0.01

1 FF FEB 11 2016

Small Fab 1-assemble as per dwg D3782

120	QC5- Inspect part completeness to step on W/O	0.00							
-----	---	------	--	--	--	--	--	--	--

120

QC Memo

0.00

D

DAS
30
9-89

Quality Control

FEB 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Large Fab ☐	Composite ☐	Supplier ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																								
Description Work Order Deviation				Disposition																																																											
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																						OTHER :																																									

Work Order ID 141770

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141770

Page 2

Item ID: D3782-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Back Leg Assembly
Start Date: 2/11/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/16/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>S7235</u>	0.00							
130									
Packaging	Memo	0.00				<u>DAS</u> <u>6</u> <u>9-69</u>			<u>FEB 16 2016</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				<u>MCS</u>			<u>FEB 16 2016</u>
Quality Control									

MCS FEB 16 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Picklist Print

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Page 1

Work Order ID: 141770

141770

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 2/11/2016

Required Date: 2/16/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C
10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3772-1 *D3772-1* Back Leg		Manufactured	No			110	Each	2.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST255				2					
				125191				2					
D3787-1 *D3787-1* Foot		Manufactured	No			110	Each	21.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST253				21					
				123684				21					
D3764-1 *D3764-1* Back Leg Fitting		Manufactured	No			110	Each	3.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST251				3					
				104909				3					
D3773-041 *D3773-041* Headrest Assembly		Manufactured	No			110	Each	1.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST252				1					
				120478				1					

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Work Order ID: 141770

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Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 2/11/2016

Required Date: 2/16/2016

Start Qty: 1.00

Required Qty: 1.00

D3786-1

Manufactured No

110

Each

11.0000

1

1

D3786-1

Sleeve

DAS
6
9.89

Location

Loc Qty

Loc Code

ST253

11

104917

11

AN45-15A

Purchased

No

110

Each

8.0000

1

1

AN45-15A

EYE BOLT

DAS
6
9.89

Location

Loc Qty

Loc Code

GA

6

m127474

6

ST340

2

m129505

2

AN5-15A

Purchased

No

110

Each

64.0000

1

1

AN5-15A

Bolt

DAS
6
9.89

Location

Loc Qty

Loc Code

GA

15

m132930

15

ST337

49

m132930

49

AN5-17A

Purchased

No

110

Each

137.0000

1

1

AN5-17A

Bolt

DAS
6
9.89

Location

Loc Qty

Loc Code

GA

36

117872

36

ST337

101

m133077

1

m134055

100

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Shop Packet Print

Page 2

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Work Order ID: 141770

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

141770

D3782-045

Start Date: 2/11/2016

Required Date: 2/16/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-15A

Purchased

No

110

Each

327.0000

2

2

AN4-15A

Bolt

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

40

120449

40

over003

100

m134055

100

ST343

187

m133284

3

m133769

184

2

MS21042L4

Purchased

No

110

Each

2,862.000

2

2

MS21042L4

Locknut

DAS

6

9-89

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

456

m133769

456

ST007

1500

m134055

1500

ST303

768

m133769

768

2

ST305

97

m130922

97

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Work Order ID: 141770

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

141770

D3782-045

Start Date: 2/11/2016

Required Date: 2/16/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

643.0000

3

3

MS21042L5

Nut

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST007

400

m134055

400

ST303

97

m133790

97

NAS1149D0463J

Purchased

No

110

Each

5,654.000

4

4

NAS1149D0463J

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST260a

1975

M134039

1975

ST263

2093

M134039

2093

ST269

1349

M130799

361

M132317

100

M132677

888

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Picklist Print

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Work Order ID: 141770

141770

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 2/11/2016

Required Date: 2/16/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

110

Each

1,240.000

5

5

NAS1149D0563.J

Washer

Location

Loc Qty

Loc Code

DAS

6

9-89

GA

53

m125807

53

ST260a

900

m133769

400

m133990

500

ST263

184

m133363

14

m133938

170

ST269

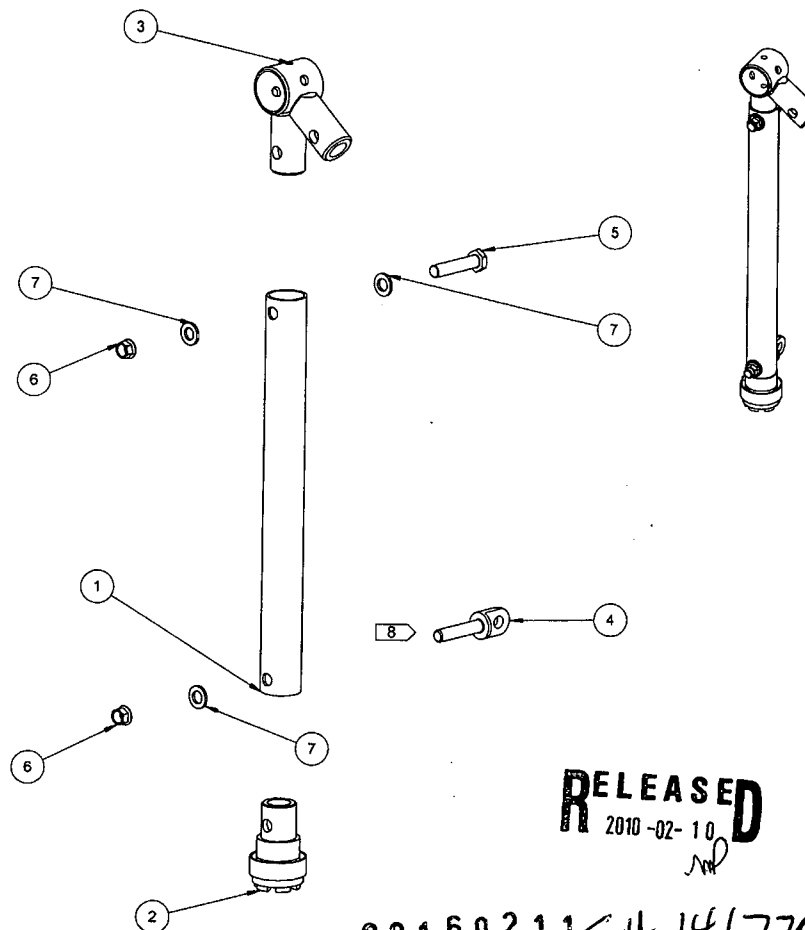
103

m128257

103

FEB 11 2016

ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)



RELEASED
2010-02-10

20160211 SH 14/770

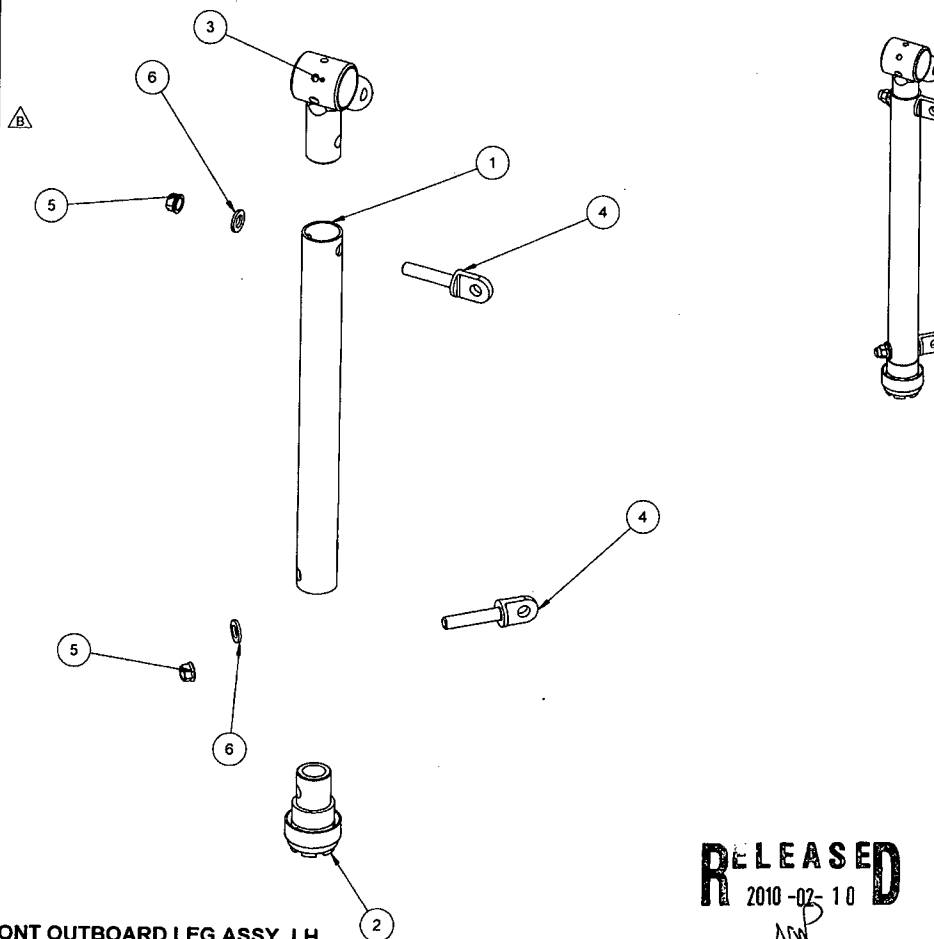
D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7	HS	10.01.21
A	NEW ISSUE	BY	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DRAWN	DRAWING NO.	REV. B
CHECKED	CHECKED	D3782	SHEET 1 OF 4
MFG. APPR.	MFG. APPR.	TITLE	SCALE
APPROVED	APPROVED	LEG ASSEMBLY	NTS
DE APPR.	DE APPR.	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.01.21		

ITEM NO.	QTY. (-043)	PART NUMBER	DESCRIPTION
1	1	D3768-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)

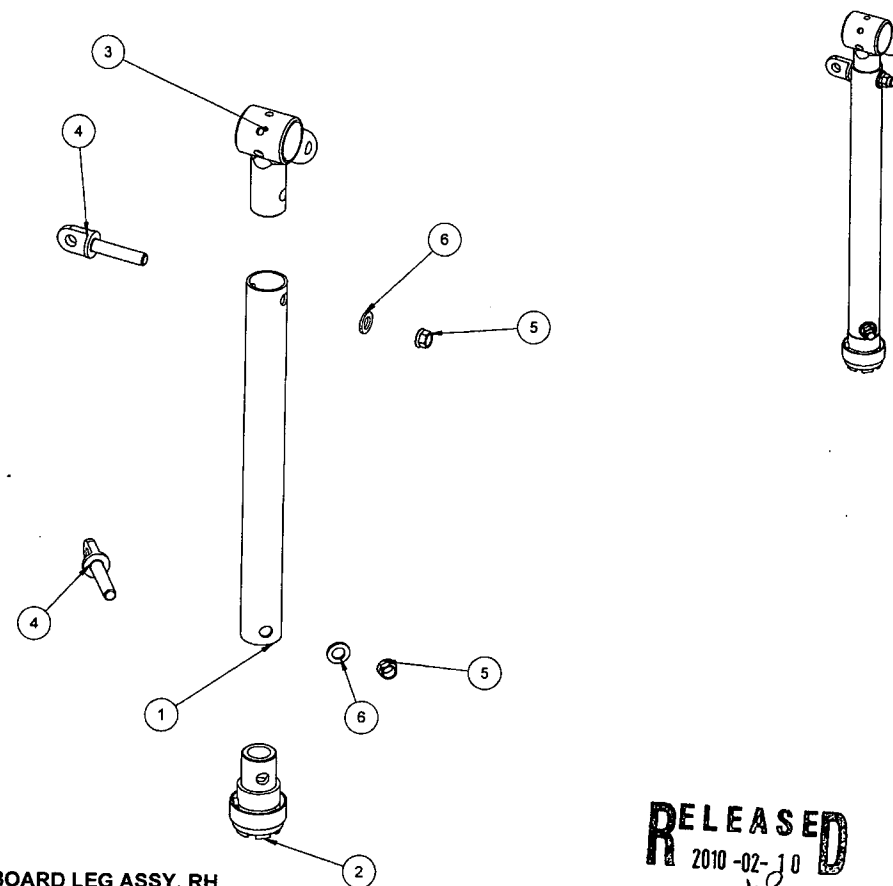


RELEASED
2010-02-10
JWP

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
DRAWN	1		
CHECKED	1	DRAWING NO. D3782	SHEET 2 OF 4
MFG. APPR.	1	TITLE LEG ASSEMBLY	SCALE NTS
APPROVED	1	DATE 10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM NO.	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



D3782-044 FRONT OUTBOARD LEG ASSY, RH

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2010-02-10

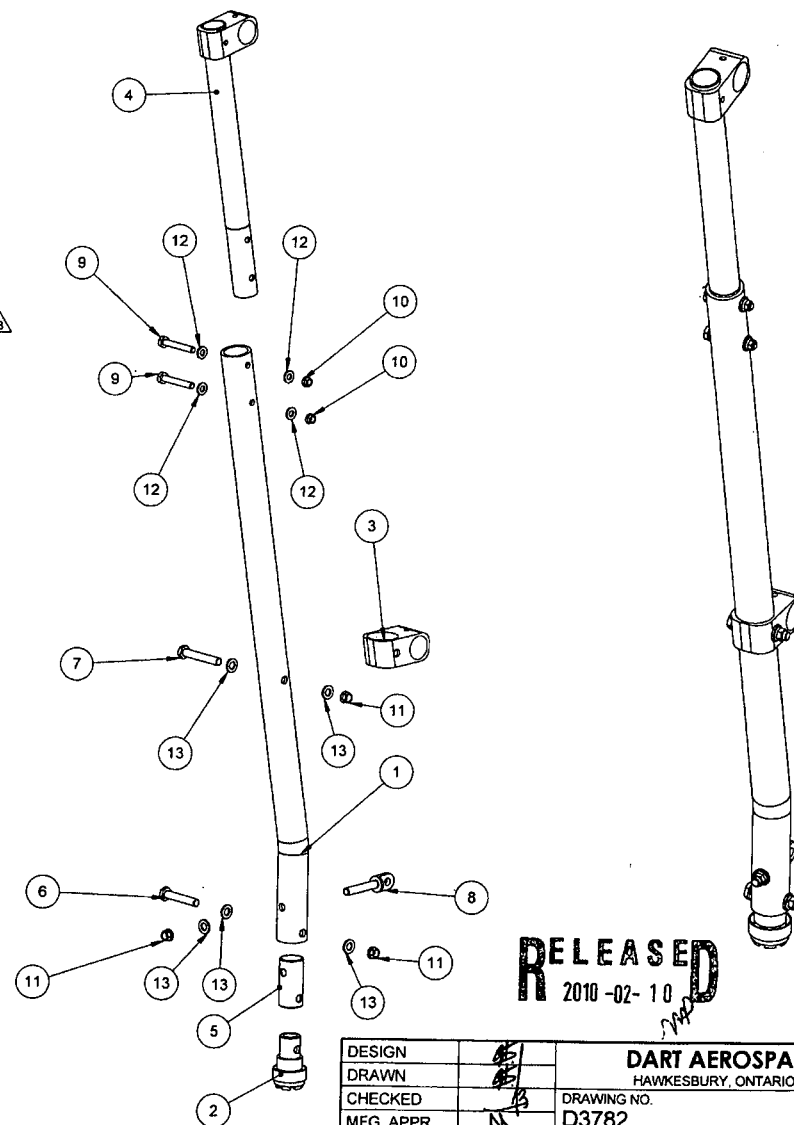
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3782	SHEET 3 OF 4
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DE APPR.		LEG ASSEMBLY	NTS
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ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

D3782-045 BACK LEG ASSY



NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 4.71 lbs

RELEASED
 2010-02-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3782	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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